

5/13

SLUT

DART AEROSPACE LTD	Work Order:	22524
Description: STA 84 bracket	Part Number:	D2803-2
Dwg: D2803 rev. <i>3/21</i>	Qty:	208









Step	Location	Procedure	By	Date	Qty
1	EXPEDITING	Issue W/O	<i>HA</i>	05.02.23	208
2	METAL	Cut blanks per template DT 8533 Material: 6061-T6 bar 10.00" x 0.50" Batch: <i>M16953 m10627</i>	<i>J</i>	05.03.14	208
3	HAAS	Machine as per folio FA102	<i>SD</i>	05.03.14	208
4	QC	Inspect Level 2	<i>SD</i>	05.03.14	8
5	QC	Inspect Level 8	<i>Ep</i>	05/03/23	8
6	METAL	Tumble & Deburr	<i>Ph.</i>	05/03/23	8
7	QC	Inspect Level 5	<i>En</i>	05/03/23	8
8	FINISHING	Chemical conversion coat per QSI 005	<i>J.G</i>	05/03/23	8
9	STORES	Identify and stock	<i>SB</i>	05/03/23	8
10	EXPEDITING	Close W/O Cost / part: <i>65.48 545 05/03/25</i>	<i>HA</i>	05.04.05	8

Rev	Date	Change	Revised By	Approved
A	00.11.06	New Issue	EC	<i>HA</i>

RELEASED

EC 00.11.06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
06/03/15	# 3	one Part scrap. extra MAT. Deflated the cutter		destroy & replace	 06/03/22	 05-03-15	 per 05-03-12	 05-03-15
05-03-22	3	8 ³⁶ pieces affected pocket milled at .240" instead of .250" which makes it .005" out of tolerance		For these 8 ³⁶ parts <u>only</u> with face stop 0.010"		 		 05-03-15
						See 22524B		

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

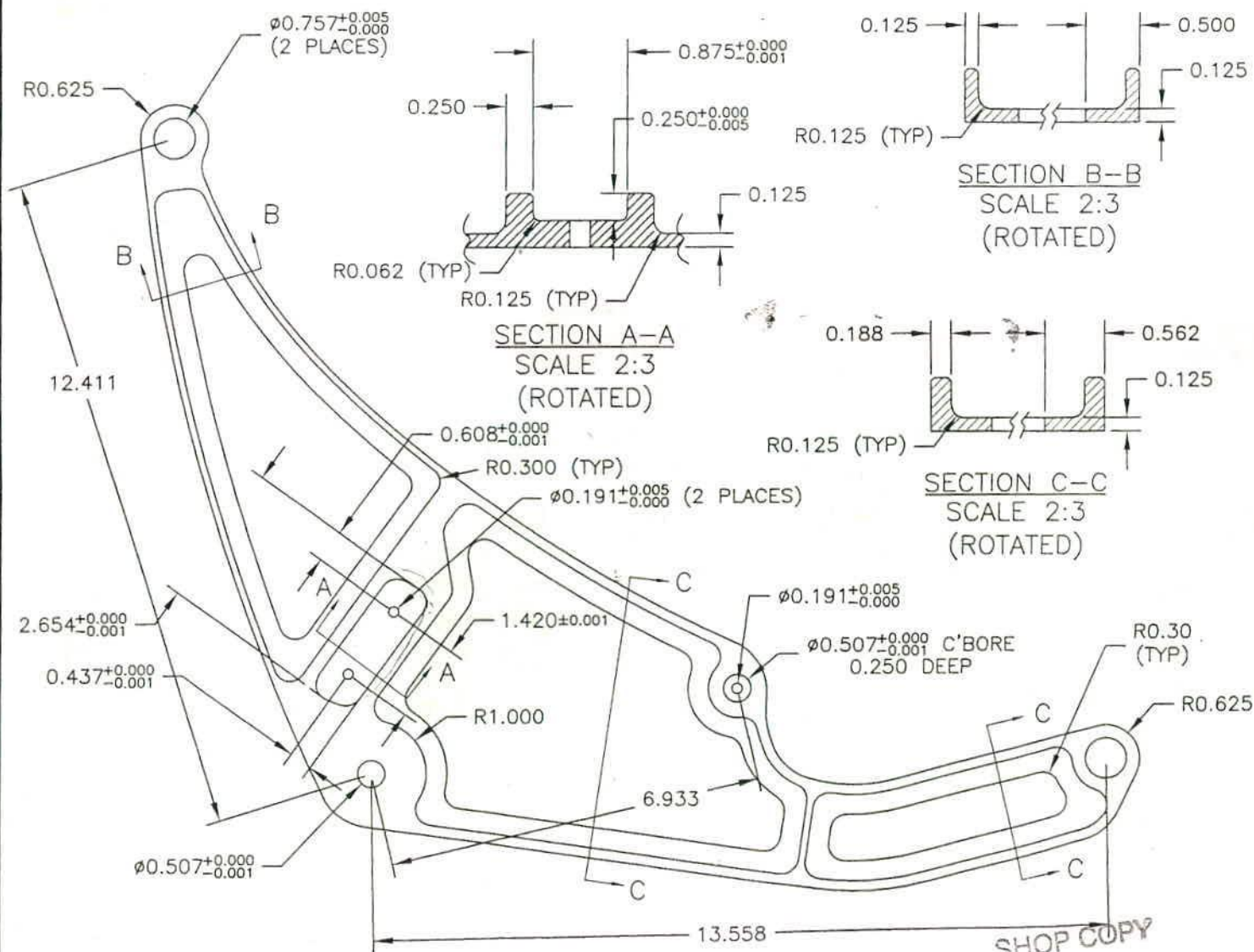
NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

PRELIMINARY ISSUE

CP

DESIGN	CP	DRAWN BY	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED		APPROVED		DRAWING NO. D2803	REV. B SHEET 1 OF 2
DATE	04.11.22	TITLE	STA 84 BRACKET	SCALE	1:3
A	00.11.07	NEW ISSUE			
B	04.11.22	ADD CUTOUTS & -043/-044			



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NO. 22524

D2803-1 BRACKET (SHOWN). D2803-2 BRACKET (OPPOSITE)

- 1) MACHINE PER DRAWING FILE "D2803.SLDPRT"
- 2) MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11) 0.500 THICK
- 3) DEBURR TO LEAVE R0.030 - 0.063 ON ALL EDGES
- 4) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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